

Date: Monday, 2/19/2007 8:07:15 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLATE
Job Number : 30742	
Estimate Number : 12670	
P.O. Number : <i>N/A</i>	Part Number : D323831
This Issue : 2/19/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3238 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 30687	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 2/26/2007 Qty: 48 Um: Each
Checked & Approved By : <i>[Signature] 07.02.19</i>	
Comment : Est Rev. A New Issue 07-01-26 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S020	6061-T6 .020 Sheet
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Comment: Qty.: 0.0252 sf(s)/Unit Total : 1.2096 sf(s):

6061-T6 .020 Sheet

Batch: *M 4894**SAD 07/02/19*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3238

Dwg Rev: *B*Prog Rev: *B**SAD 07/02/19*

2-Deburr if necessary

\*\*\*Use cutting file D3238-21-23-25\*\*\*\*\*

*FF 07-02-20 48*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD**07/02/19**48*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*SF 07/02/19*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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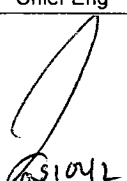
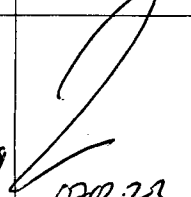

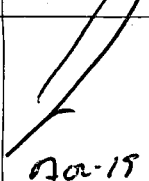
Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*M.A**a.m**07/02/19**48*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/02/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/19	2.0	5 pieces were scrap because off the offset was not Right	 06/10/22	Scrap and destroy replace	SAB 07/02/19	 07/02/22	 06/10/22	 07-15

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:07:15 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 30742

Part Number: D323831

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Lu 7/2/21 (46) count 2x*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5

*Lu 7/2/21 (46)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(46) 7/07/02/22*

Job Completion



*u of 0222*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

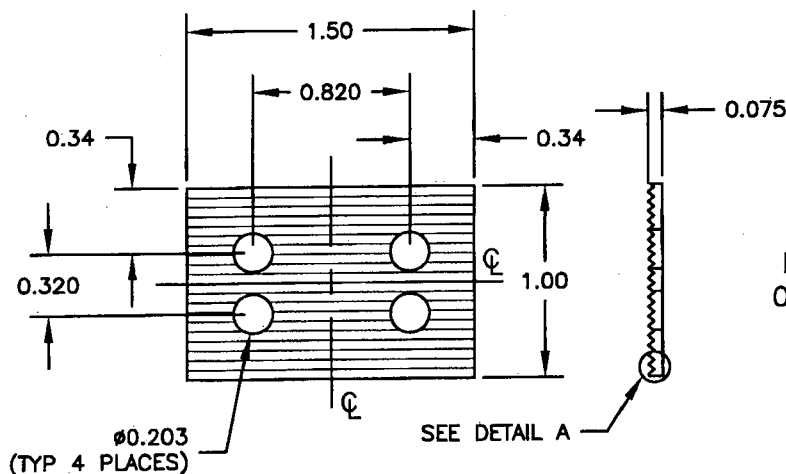
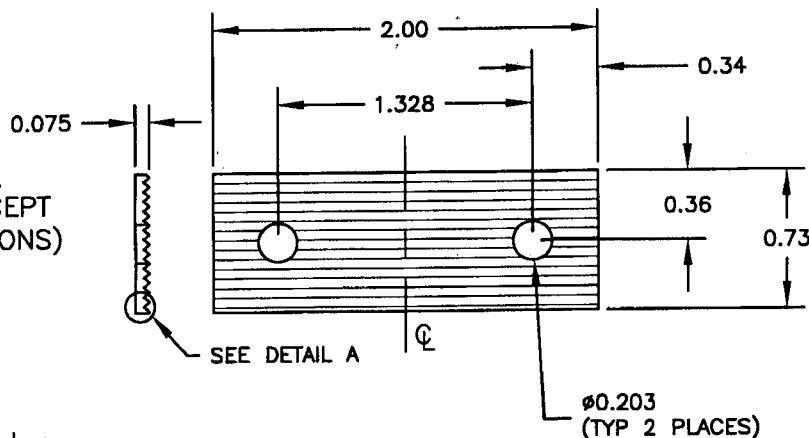
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. B SHEET 1 OF 3
DATE 07.01.17	TITLE PLATE		SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	

**D3238-1 PLATE (SHOWN)**  
D3238-11 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)



**D3238-3 PLATE (SHOWN)**  
D3238-13 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

**RELEASED**

07.01.22

**NOTES:**

- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:  
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037  
(REF DART SPEC M2024T3S)  
-11/-13/-15/-31/-33/-35 PLATE:  
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR  
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 004 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT  $\phi$

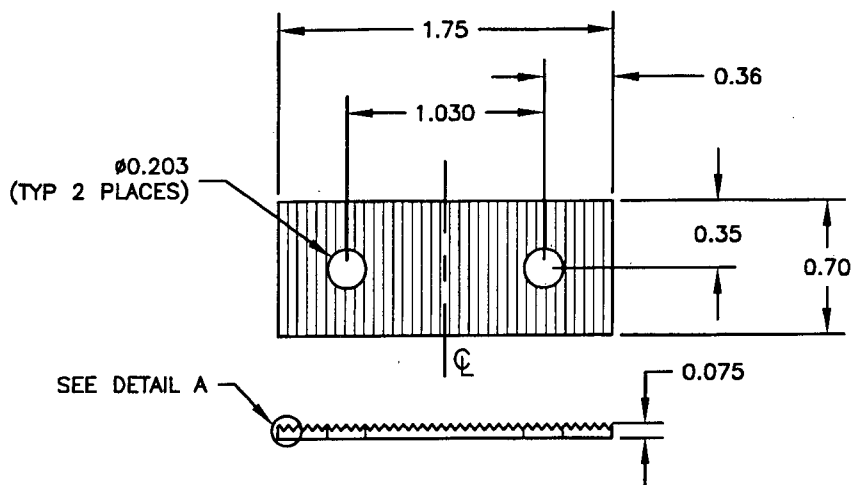
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WITHOUT NOTICE  
WORK ORDER  
NO. 30742

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**DART**

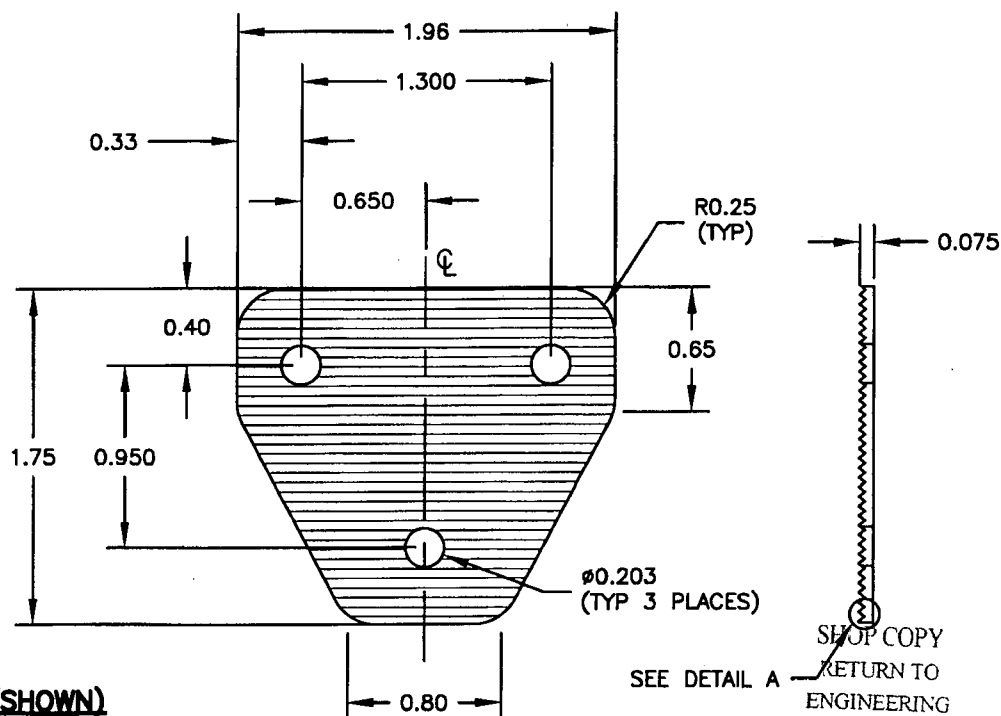
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CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. B SHEET 2 OF 3
DATE 07.01.17		TITLE PLATE	SCALE 1:1



**D3238-5 PLATE (SHOWN)**  
D3238-15 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

**RELEASED**

07.02.17



**D3238-21 PLATE (SHOWN)**  
D3238-31 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

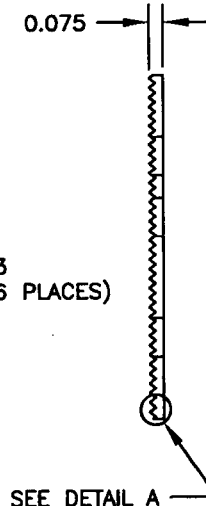
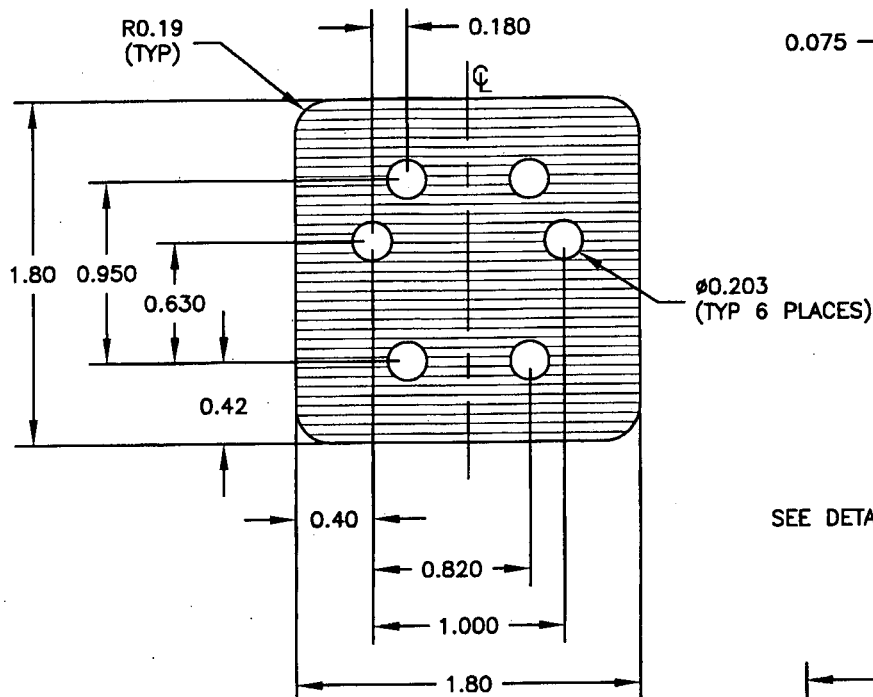
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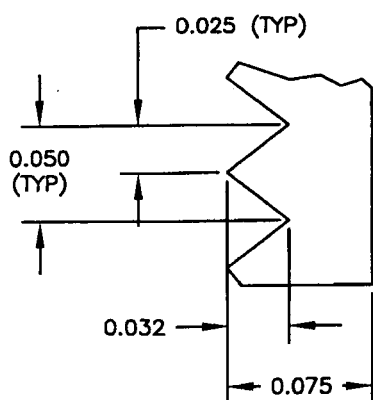
**DART**

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. B SHEET 3 OF 3
DATE 07.01.17	TITLE PLATE		SCALE 1:1

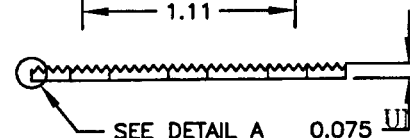
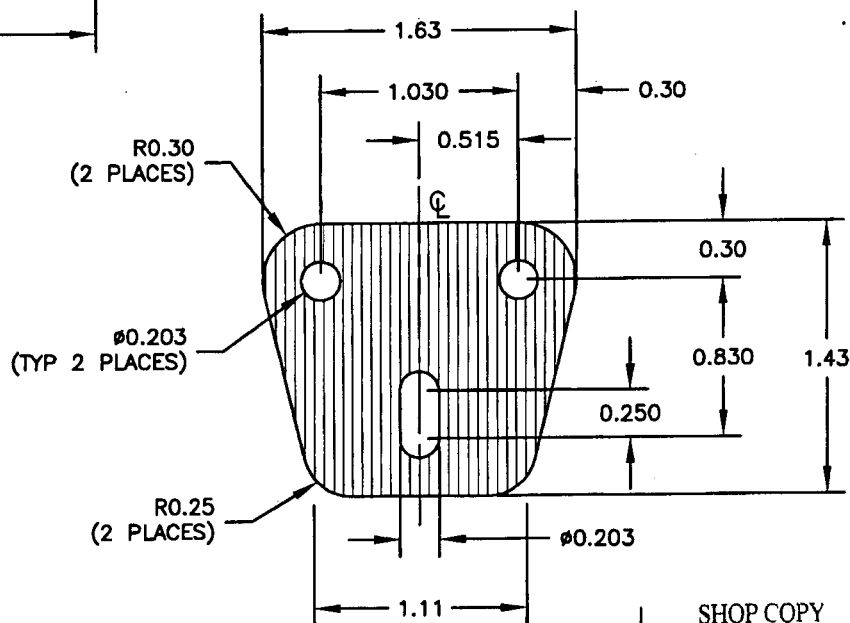
**RELEASED**

07.01.22

**D3238-23 PLATE (SHOWN)**  
D3238-33 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)



**DETAIL A**  
RIDGE DETAIL (VIEW MAY BE ROTATED)  
SCALE 10:1



**D3238-25 PLATE (SHOWN)**  
D3238-35 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

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DART AEROSPACE LTD		Work Order:	30742
Description:		Part Number:	032 38 31
Inspection Dwg:	Rev:	Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

**X**

**X**

[illegible]

Measured by:	JAN
Date:	07/02/19

Audited by:	<i>S. J.</i>
Date:	07/02/19

<b>Prototype Approval:</b>	
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	